

Blue

Work Order ID 62615

October 5, 2010 11:40:13 AM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RJ*

Date: 10/10/05 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2650 | Rev F |

100 0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A HJ

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:14 AM



Page 2

Item ID: D206-642-441

Accept



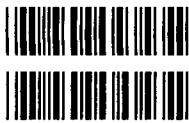
Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

0.00

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

> DP 10-10-6

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M15778/M12507 BE 10-10-6

4-Grind weld flush to cap on top surface only.

BE 10-10-6

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to 0.0312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

10-10-7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:19 AM



Page 3

Item ID: D206-642-441

Accept



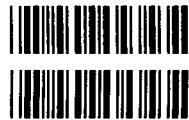
Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/07

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/07

(70)

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

8/10/07

1 - 8/10/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:19 AM

Page 4

Item ID: D206-642-441

Accept



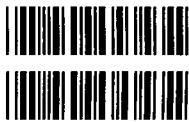
Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

QC3- Inspect Part Finish

0.00

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:24 AM



Page 5

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

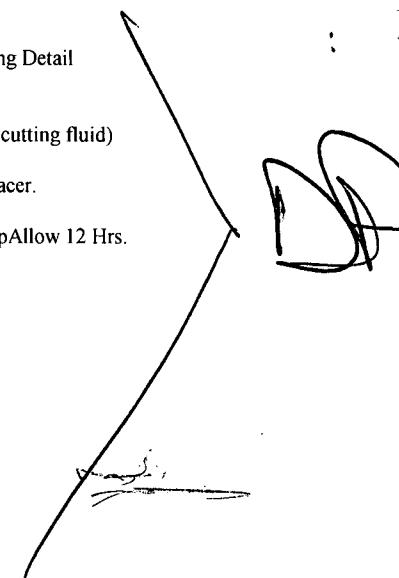
1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cuttingStart Date: 10-10-7Time: 115pmFinish Date: 10/10/12Time: 8:40AMA/R Sikaflex M 115 114Sikaflex expiry date: 11-1-30

10-10-7



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:25 AM



Page 6

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

160



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004
and Dwg D2650. Remember to back drill each hole to 0.25" before welding the
other side. Use aluminum rod.

A/R Aluminum Rod

M111385 BE10/10/12

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE10/10/12
3 BE10/10/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

Page 7

October 5, 2010 11:40:30 AM

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

170

Operation
Description

HandFinishing

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Skidtubes

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650

BE 10/10/12

180



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/10/13

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/10/13

(X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:30 AM



Page 8

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Pressure Wash per QSI005 4.3

0.00

=> M

10/10/18

HandFinish

Memo

0.00

1 0

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

211



SprayPaint

Memo

0.00

ZT 10-10-23 (1)

Spray Painting

PRIME B 114424

PAINT DELFLEET BLUE B 115509

CLEAR DELFLEET B 113314

221



QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

W 10-10-25 (1)

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:36 AM



Page 9

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

230



HandFinish

Hand Finishing

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

~7 M

10/10/25

1

9

0.00

HandFinishing

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R□□Sikaflex-291□ AA114093Sikaflex expiry date:□ 10/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R□□Sikaflex-291□ AA114093Sikaflex expiry date:□ 10/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4□

Batch: AA114093

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 62615

October 5, 2010 11:40:36 AM



Page 10

Item ID: D206-642-441

Accept



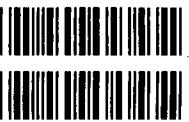
Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S1010126

(X)

250



Packaging

Packaging

Packaging

0.00

0.00

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPP 62624

260



Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:40:02 AM

Page 1

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

IPP Rev:I 08-05-01 add QC3 DD verified by:EC

IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K

10.09.27 SS washers for wearplates EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| ALS4-1032-130 | | Purchased | | No | | 230 | Each | 1,214.000 | 60 | 60 | 60 | 10/10/25 | |

Insert

| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | |
|--|--|-----------------|----------------|-----------------|-----|
| | | PKG11 | 1165 | | |
| | | 114723 | 1165 | | |
| | | ST282 | 10 | | |
| | | 110511 | 10 | A1115911 | X60 |
| | | ST381 | 39 | | |
| | | 114654 | 39 | | |

| | | | | | | | | | | | | |
|------------|---------------|-----------|----|--|-----|------|--------|---|---|----|----------|--|
| AN960JD10L | NAS1149D0332J | Purchased | No | | 230 | Each | 0.0000 | 2 | 2 | y2 | 10/10/25 | |
| Washer | | | | | | | | | | | | |

| | | | | | | | | | | | | |
|------------|---------------|-----------|----|--|-----|------|---------|---|---|----|----------|--|
| AN960JD416 | NAS1149D0463J | Purchased | No | | 230 | Each | 24.0000 | 1 | 1 | el | 10/10/25 | |
| Washer | | | | | | | | | | | | |

| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | |
|--|--|-----------------|----------------|-----------------|----|
| | | ST300 | 24 | | |
| | | 113288 | 24 | M115672 | X1 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

October 5, 2010 11:40:02 AM

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

446.0000

2

2



Cherry Rivet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST311 | 446 | |
| 112314 | 4 | |
| 113539 | 44 | |
| 113973 | 398 | |

CR3212-4-03

Purchased

No

230

Each

1,888.000

2

2



Cherry Rivet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST311 | 1888 | |
| 111359 | 5 | |
| 112314 | 2 | |
| 114436 | 448 | |
| 114450 | 71 | |
| 114859 | 1362 | |

D2620

Manufactured

No

110

Each

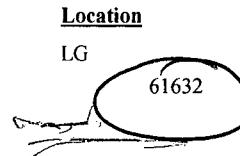
8.0000

1

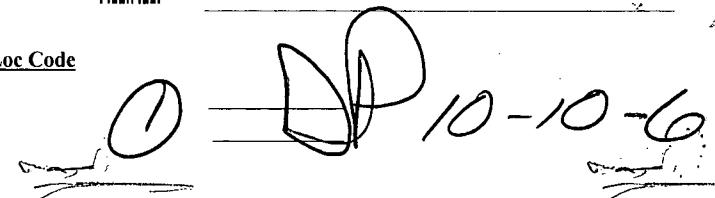
1



Skidtube, 206 Skidtube



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 8 | |
| 61632 | 8 | |



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 3

October 5, 2010 11:40:03 AM

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2646



Manufactured No

110

Each

50.0000

1

1

1610125

Aft Cap

Blue ✓

Location Loc Qty Loc Code

FP-4 45

57332 45

fp5 1

61752 1

FP6 4

52663 4

D2647



Manufactured No

140

Each

66.0000

1

1

Cap

Location Loc Qty Loc Code

FP 66

55352 66

D2649



Manufactured No

170

Each

65.0000

23

23

Cross Bolt Spacer

Location Loc Qty Loc Code

LG 65

58545 2

60652 4

61496 59

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:40:04 AM

Page 4

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1



Manufactured No

230 Each 622.0000

22 22

HL 1010125

Plug

blue

| | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|-----------------|----------------|-----------------|
| | FP | 252 | |
| | 51530 | 152 | |
| | 61751 | 100 | X22 |
| | fpa | 370 | |
| | 53349 | 235 | |
| | 57869 | 135 | |

D2651-3



Manufactured No

230 Each 626.0000

22

HL 1010123

O-Ring

| | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|-----------------|----------------|-----------------|
| | FP | 626 | |
| | 46114 | 130 | X22 |
| | 61962 | 496 | |

D2654-7



Manufactured No

160 Each 0.0000

1

① DP 10-10-7

Web

D2680-041



Manufactured No

170 Each 29.0000

1

1 BS 10/10/12

Nut Plate

blue

| | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|--|-----------------|----------------|-----------------|
| | SP021 | 29 | |
| | 55366 | 29 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:40:04 AM

Page 5

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3535-15



Manufactured No

230

Each

6.0000

1

1



M 10/10/25

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP18 6

61241 6

D3535-23



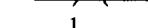
Manufactured No

230

Each

19.0000

1



X 1

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP 7

61830 7

FP021 20

60231 11

D3535-37



Manufactured No

230

Each

9.0000

1



X 1

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP 9

56101 9

D3536-15



Manufactured No

230

Each

10.0000

1



M 10/10/25

Gasket

| <u>Location</u> | <u>Qty</u> | <u>Loc Code</u> |
|-----------------|------------|-----------------|
|-----------------|------------|-----------------|

FP 9

56055 1

60875 8

FP11 1

59238 1

X 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:40:05 AM

Page 6

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3536-23



Manufactured No

230

Each

8.0000

1

1

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP011
61237

8

8

D3536-37



Manufactured No

230

Each

8.0000

1

1

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP
56102

8

8

D3537-1



Manufactured No

230

Each

14.0000

6

6

Wearpad

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP
55465

1

1

D3537-3



Manufactured No

230

Each

8.0000

1

1

Wearpad

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

FP17
60866

8

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 7

October 5, 2010 11:40:05 AM

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

230

Each

1,585.000

2

2

MS27039-1-08

Screw

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST291 | 1585 | |
| <u>110835</u> | 473 | |
| <u>114718</u> | 112 | x2 |
| <u>115108</u> | 1000 | |

4P 10110125

MS27039-4-06

Purchased

No

230

Each

108.0000

1

MS27039-4-06

Screw

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| ST292 | 108 | |
| <u>109061</u> | 14 | y1 |
| <u>115460</u> | 94 | |

4P 10110125

MS27039C1-08

Purchased

No

230

Each

1,077.000

60

SCREW

| Location | Loc Qty | Loc Code |
|---------------|---------|----------|
| FP | 276 | |
| <u>115336</u> | 276 | |
| ST293 | 801 | |
| <u>115589</u> | 800 | x60 |
| 19185 | 1 | |

4P 10110125

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

October 5, 2010 11:40:06 AM

Page 8

Work Order ID: 62615



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,239.000

60

60

Washer



101012

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST297 | 5239 | |
| 113524 | 10 | |
| 113737 | 150 | |
| 115000 | 125 | |
| 115698 | 78 | |
| <u>115816</u> | 1276 | X60 |
| 115832 | 3600 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| X | | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| 1 | | | | D2654-3 | WEB |
| | 1 | | | D2654-5 | WEB |
| | | 1 | | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

F

SEARCHED
INDEXED
FILED
SERIALIZED
UNCONTROLLED DOCUMENT
SUBJECT TO ANNUAL REVIEW
VIA FAX OR E-MAIL
WORK ORDER
NO. 607-005
BY 10-10-05

RELEASED
08-07-23 PM

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150° IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|------------|--|--|----------|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | RMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | REV. F | |
| MFG. APPR. | D2650 | SHEET 1 OF 6 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR SHOWN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

8 7 6 5 4 3 2 1

D

C

B

A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

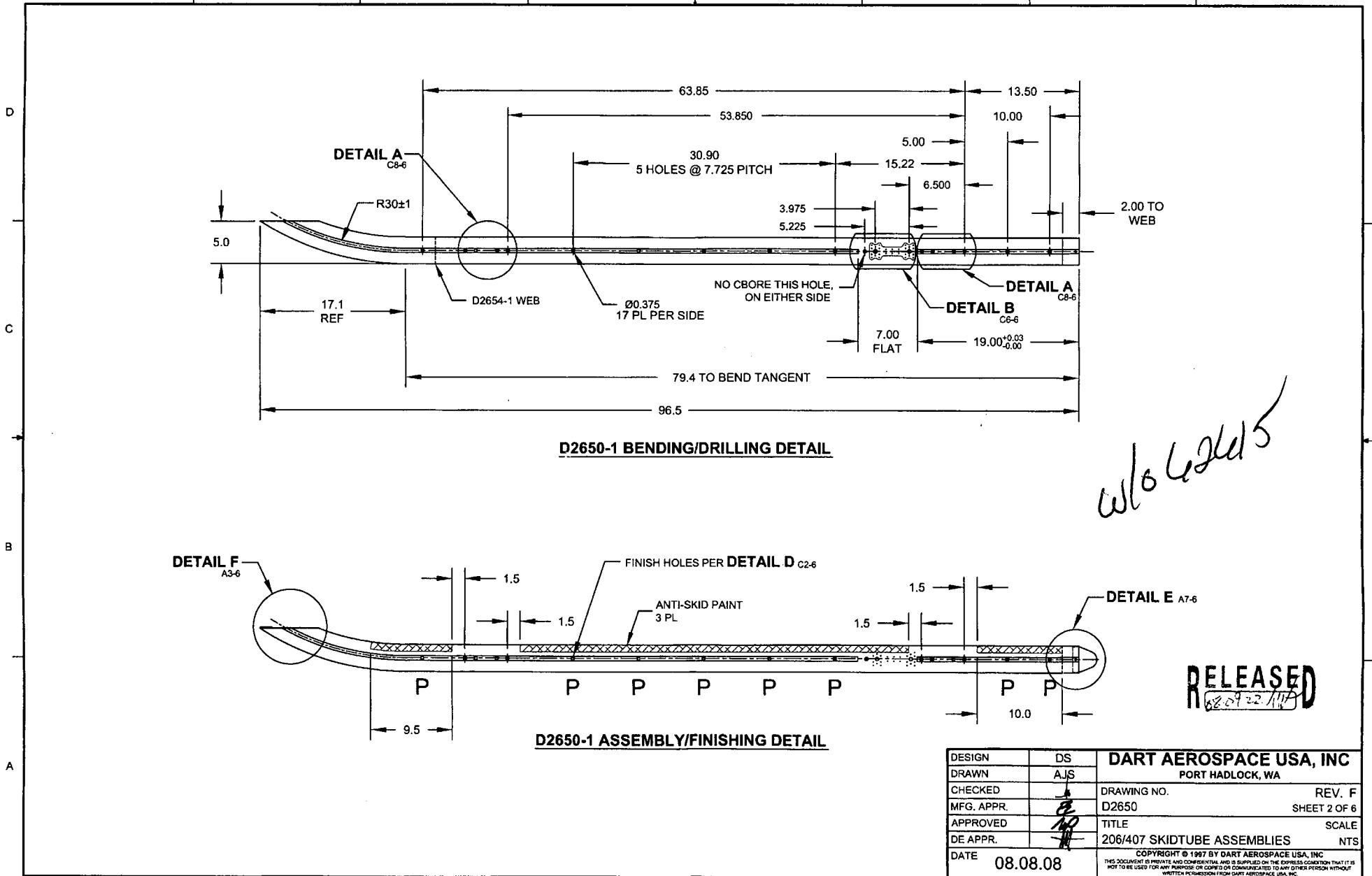
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

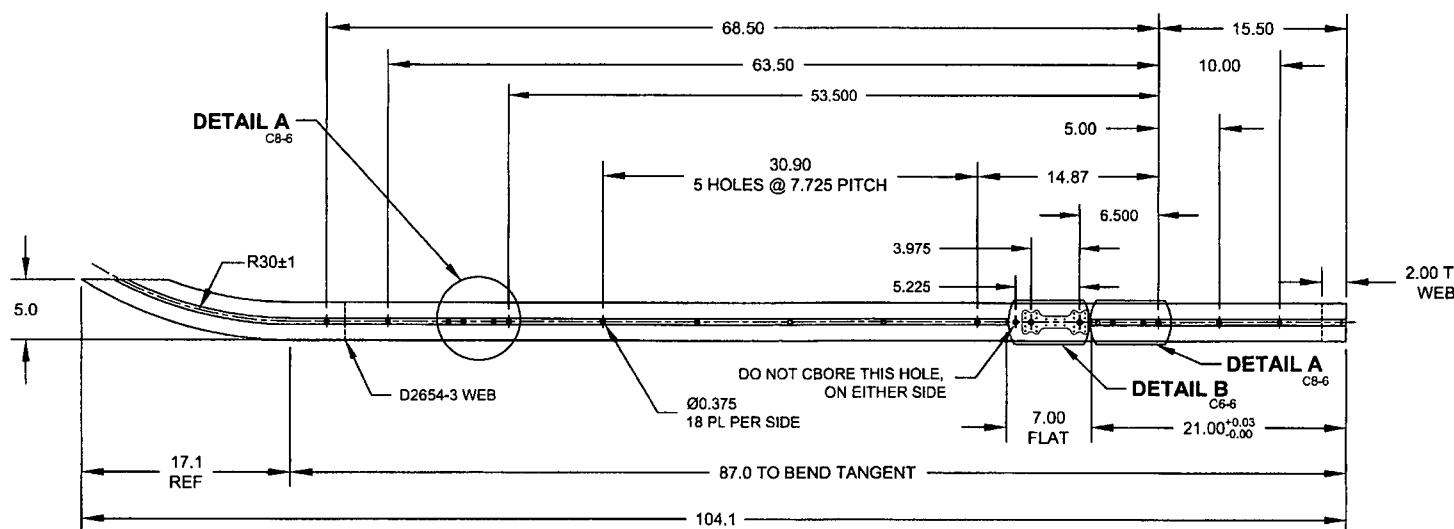
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

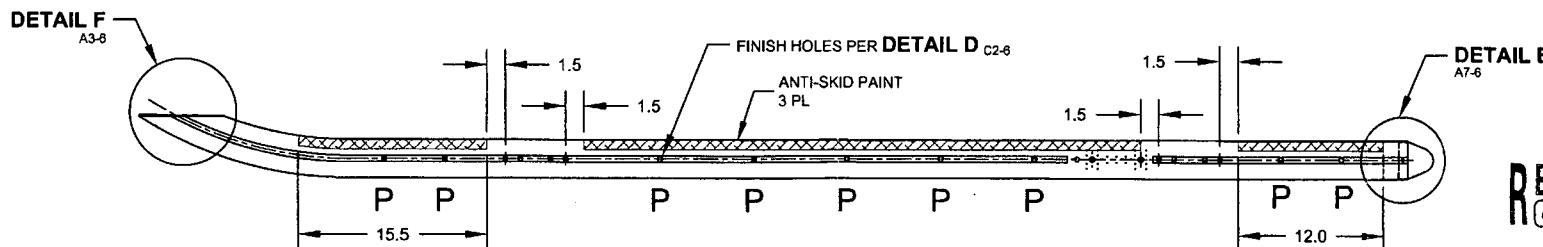
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

DETAIL A
C8-6**D2650-3 BENDING/DRILLING DETAIL**

Wb 6/26/05

**D2650-3 ASSEMBLY/FINISHING DETAIL**RELEASED
08-07-02/17/08

| DESIGN | DS | DART AEROSPACE USA, INC PORT HADLOCK, WA |
|------------|----------|---|
| DRAWN | AJS | |
| CHECKED | | DRAWING NO. REV. F |
| MFG. APPR. | | D2650 SHEET 3 OF 6 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED EXCEPT AS AUTHORIZED IN THE DRAWING BY A PERSON WITHIN WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

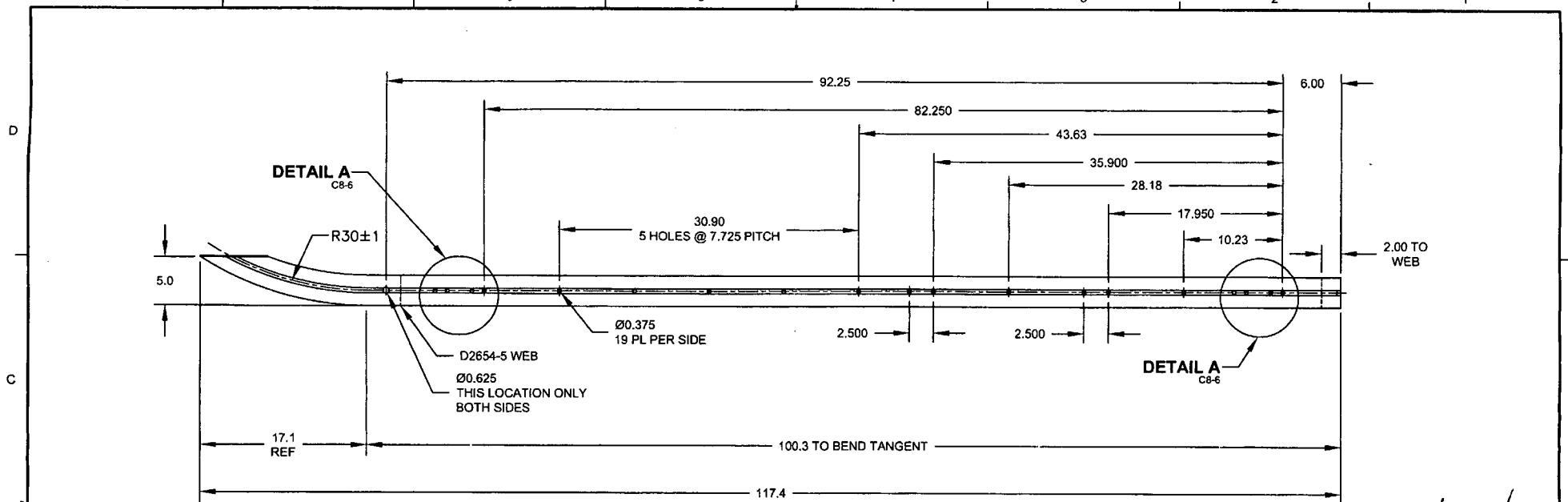
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

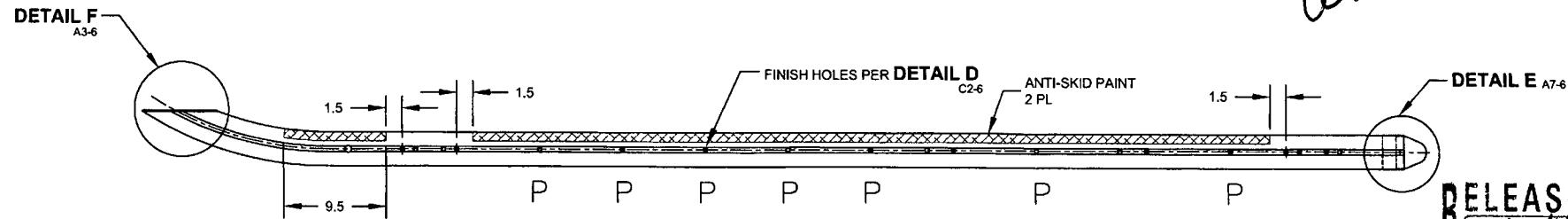
8 7 6 5 4 3 2 1



D2650-5 BENDING/DRILLING DETAIL.

w/o A26015

B



A

D2650-5 ASSEMBLY/FINISHING DETAIL

| DESIGN | DS | DART AEROSPACE USA, INC | |
|------------|--|---|--------------|
| DRAWN | AJS <th data-cs="2" data-kind="parent">PORT HADLOCK, WA</th> <th data-kind="ghost"></th> | PORT HADLOCK, WA | |
| CHECKED | J | DRAWING NO. | REV. F |
| MFG. APPR. | E | D2650 | SHEET 4 OF 6 |
| APPROVED | H | TITLE | SCALE |
| DE APPR. | H | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC | |
| | | ALL RIGHTS RESERVED. THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION AND IS PROTECTED BY LAW. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

8 7 6 5 4 3 2 1

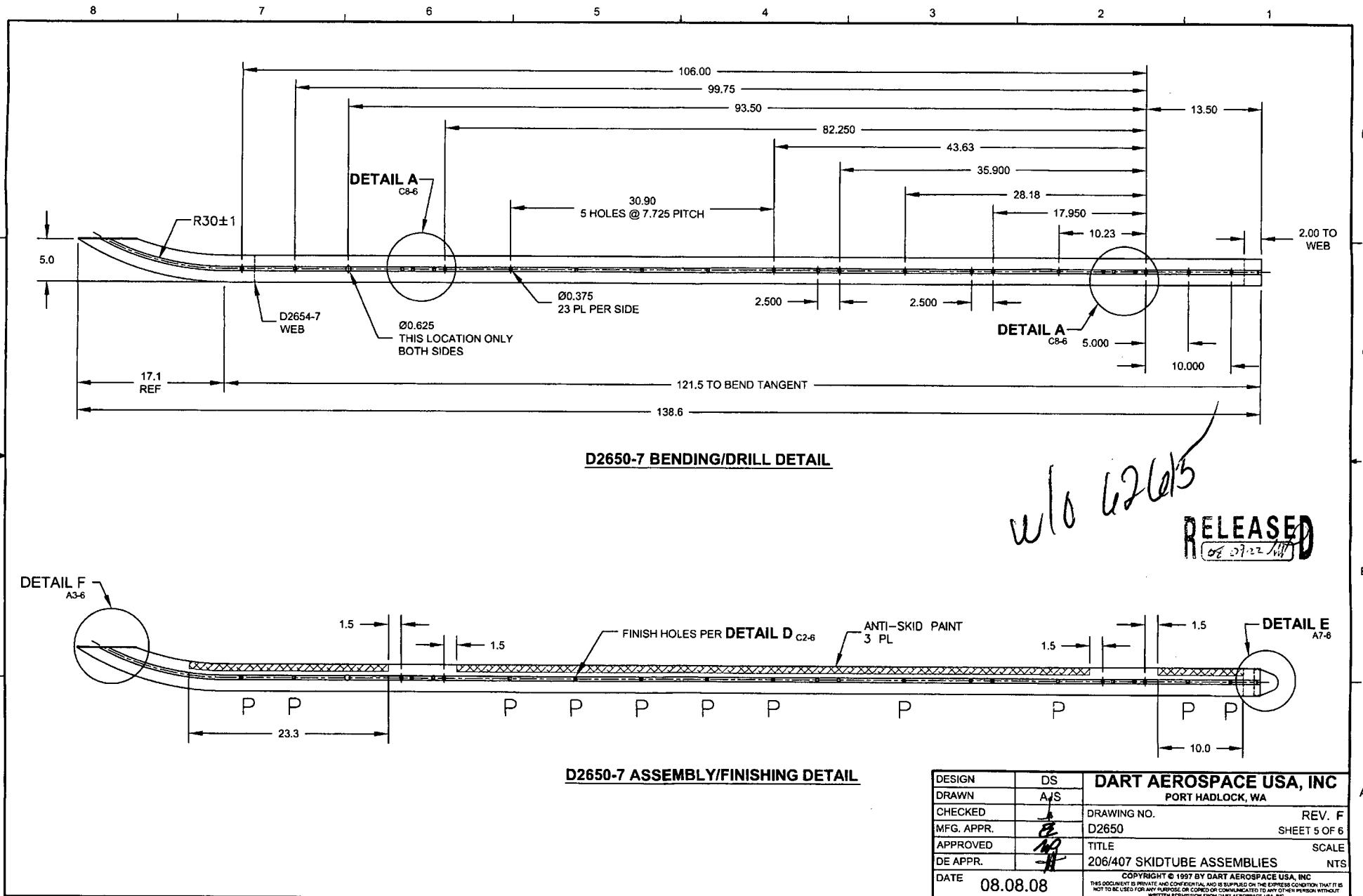
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



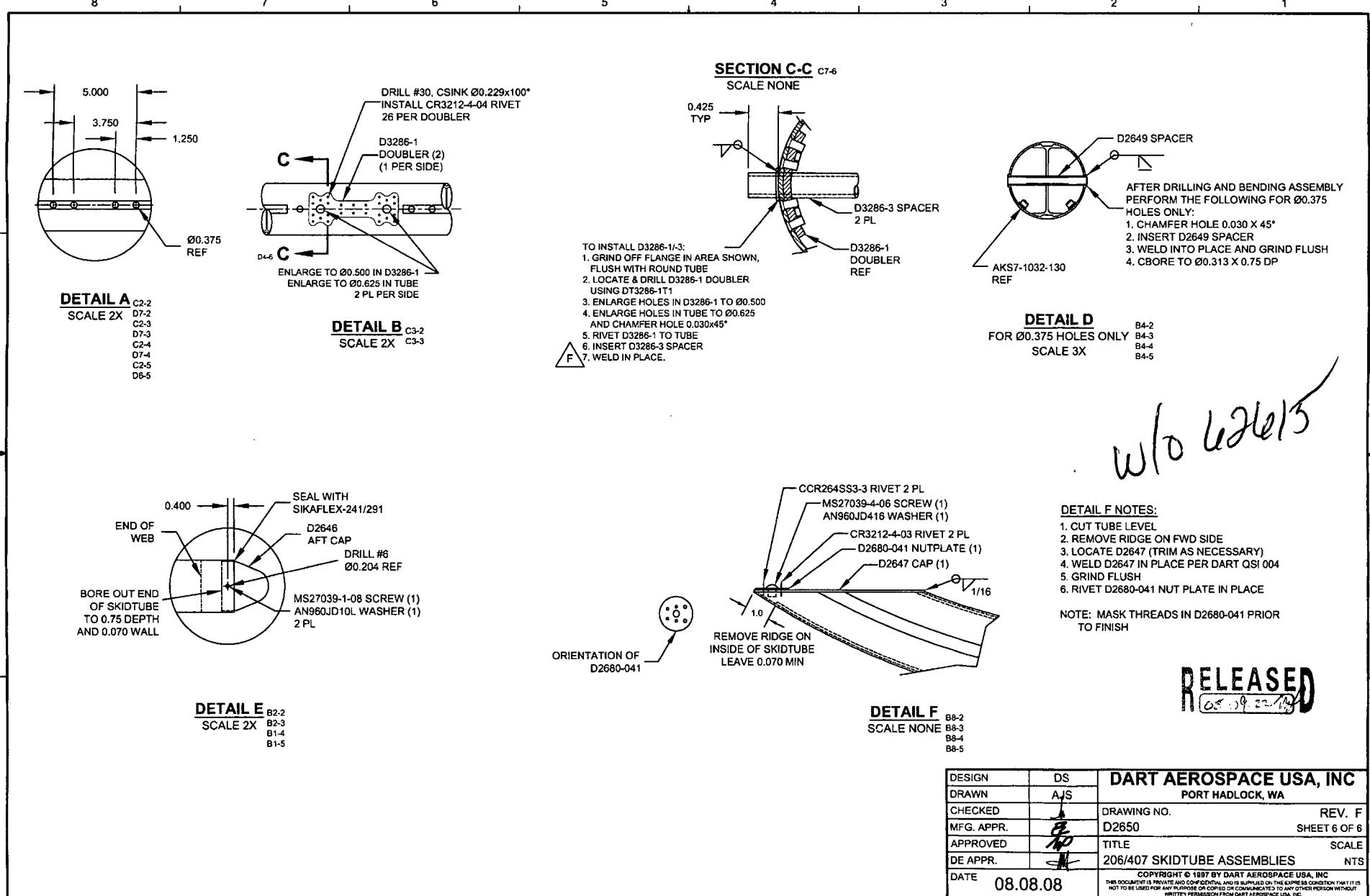
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622808
Part number: D206-L42-541
Description: 206 skid
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 10-09-30

Welder Barclay Elliott Date of Test Coupon 10-09-30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.